

Date: Thursday, 2/23/2006 10:21:33 AM  
 User: Kim Johnston

## Process Sheet

10

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: LATCH MODIFICATION KIT (AFT & SIDE DOOR)
<b>Job Number</b>	: 25905		
<b>Estimate Number</b>	: 12006		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: DSI 9189011
<b>This Issue</b>	: 2/23/2006	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: DSI 9189 REV A
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: N/A	<b>Drawing Revision</b>	: A
	<b>Type</b> : PURCHASED PARTS	<b>Material</b>	: N/A
<b>Written By</b>	: SEE COMMENT BELOW	<b>Due Date</b>	: 3/10/2006
<b>Checked &amp; Approved By</b>	: [Signature] 06.02.23	<b>Qty:</b>	4
<b>Comment</b>	: Est. A 00.06.26 New Issue EC	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Provide photocopy of DSI 9189

2.0

D2463

1/2" Seal

**Comment:** Qty.: 0.2083 f(s)/Unit Total: 0.8332 f(s)

Neoprene Seal

Pick:

Qty Part number

Description

Batch

2

D2463-0025

Neoprene seal

B21350 ✓

3.0

D2585

Latch Clamp

**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Latch Clamp

Pick:

Qty

Part number

Description

Batch

2

D2585

Mouting channel

B25328 ✓

4.0

D2586

Door Latch

**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Door Latch

Pick:

Qty

Part number

Description

Batch

2

D2586

Latch

B24562 ✓

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/23/2006 10:21:33 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH MODIFICATION KIT (AFT &SIDE DOOR)

Job Number: 25905

Part Number: DSI 9189011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Latch Plate

Pick:

Qty Part number Description Batch

2 D2621 Latch plate

B24545 ✓

6.0

D2980

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Latch Plate

Pick:

Qty Part number Description Batch

2 D2980 Latch plate

B12565 ✓

7.0

D2589

Keys, Key Chain



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Keys, Key Chain

Pick:

Qty Part number Description Batch

1 D2589 Keys, key chain

B23083 ✓

8.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part number Description Batch

2 AN960JD10 Washer

M19521 ✓

9.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty Part number Description Batch

2 MS21042-3 / Nut (or L3)

M19079

M6931 7mcx M6339 1mcx

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 20 Date: 06/03/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/23/2006 10:21:33 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH MODIFICATION KIT (AFT & SIDE DOOR)

Job Number: 25905

Part Number: DSI 9189011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Pick:

Qty

Part number

Description

Batch

2

MS27039-1-18

Screw

M12307 - 106/3/02 (4)

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206103102

(4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: —

REV.A

C 206103109

(4)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206103109 (4)

Job Completion



W 06-03-09

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9189	REV. A SHEET 1 OF 3
DATE 00.05.23		TITLE AFT AND SIDE DOOR LATCH MOD.	SCALE NTS
A	00.05.23	NEW ISSUE	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWINGS: D350-588 REV. A OR EARLIER  
D350-589 REV. A OR EARLIER

REF. CANADIAN STC: SH92-41  
US FAA STC: SH1012NE

### INTRODUCTION

THE PURPOSE OF THE DSI 9189-011 KIT IS TO PROVIDE THE HARDWARE TO REPLACE THE D2443 LATCHES (REF. HARTWELL PART NUMBERS H605S190A496 OR H2818-3S125A OR H605K3240) WITH D2586 LATCHES.

### PART LIST

Qty -011	Part Number	Description
X	DSI 9189-011	LATCH MODIFICATION KIT
2	D2463-0025	1/2" FOAM SEAL
2	D2585	MOUNTING CHANNEL
2	D2586	LATCH
1	D2589	KEYS, KEY CHAIN
2	D2621	LATCH PLATE
2	D2980	LATCH PLATE
2	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW

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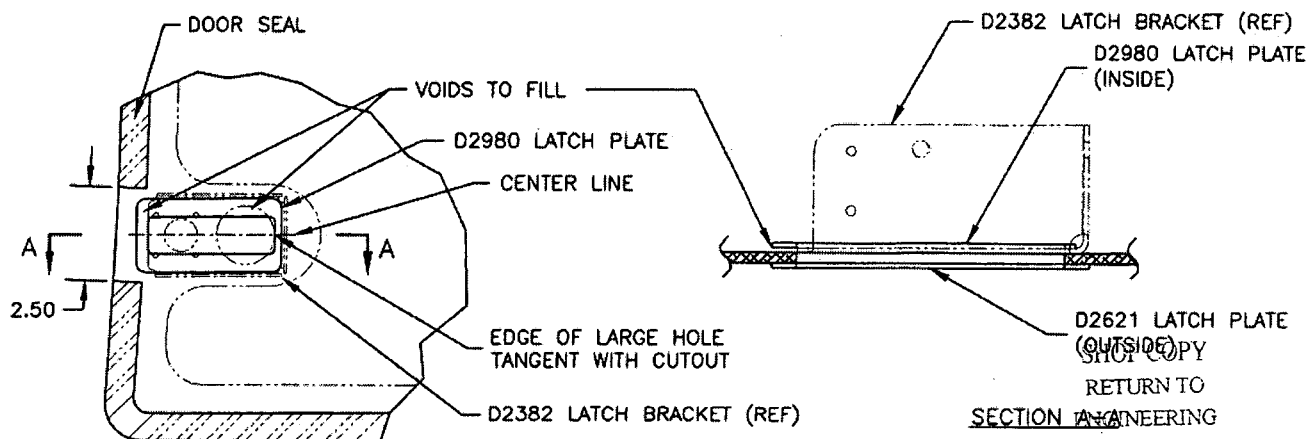
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**DART**

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9189	REV. A SHEET 2 OF 3
DATE 00.05.23		TITLE AFT AND SIDE DOOR LATCH MOD.	SCALE NTS

**PROCEDURE:**  
**AT EACH LATCH LOCATION**

1. REMOVE EXISTING D2443 LATCH AND D2383 LATCH BRACKET COVER FROM THE DOOR. DO NOT REMOVE D2382 LATCH BRACKET.
2. REMOVE 2.5" (MAX) OF SEAL FROM EDGE OF THE DOOR PER FIGURE 1.
3. DRAW A LINE CONNECTING THE CENTRES OF THE TWO LARGE HOLES FOR THE EXISTING LATCHES.
4. LINE UP THE INSIDE EDGE OF THE D2980 LATCH PLATE WITH THE EDGE OF LARGER LATCH HOLE AS SHOWN IN FIGURE 1. MAKE SURE THE D2980 LATCH PLATE IS CENTERED ON THE LINE CREATED AT STEP 3.
5. USING THE D2980 LATCH PLATE AS A TEMPLATE, MARK THE CUTOUT PROFILE FOR THE LATCH.
6. CUT A HOLE IN THE DOOR PER THE PROFILE CREATED AT STEP 5. TRIM TO FIT D2586 LATCH.
7. CLEAN THE INSIDE OF D2382 AND OUTSIDE OF THE DOOR IN THE VICINITY OF THE D2621 AND D2980 LATCH PLATES WITH ACETONE.
8. INSTALL D2621 LATCH PLATE OUTSIDE AND D2980 LATCH PLATE INSIDE OF THE DOOR AS SHOWN IN SECTION A-A USING 5 MIN. EPOXY OR PRC. ENSURE THAT THE LATCH PLATES LINE UP WITH THE RECTANGULAR CUTOUT FOR THE D2586 LATCHES. CLAMP LATCH PLATES IN PLACE. FILL THE VOID BETWEEN THE D2621 AND D2980 LATCH PLATES AS SHOWN IN FIGURE 1 WITH 5 MIN. EPOXY OR PRC. WIPE AWAY EXCESS EPOXY OR PRC FROM ALL AROUND THE LATCH PLATE INSTALLATION. ALLOW AT LEAST 15 MIN. BEFORE REMOVING CLAMPS AND PROCEEDING TO THE NEXT STEP.
9. INSTALL REPLACEMENT D2463-0025 NEOPRENE SEAL OVER THE D2980 LATCH PLATE.
10. INSTALL D2586 LATCH AND D2585 MOUNTING CHANNEL PER FIGURE 2.



**FIGURE 1: TYPICAL DOOR CUTOUT**

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9189	REV. A SHEET 3 OF 3
DATE 00.05.23		TITLE AFT AND SIDE DOOR LATCH MOD.	SCALE NTS

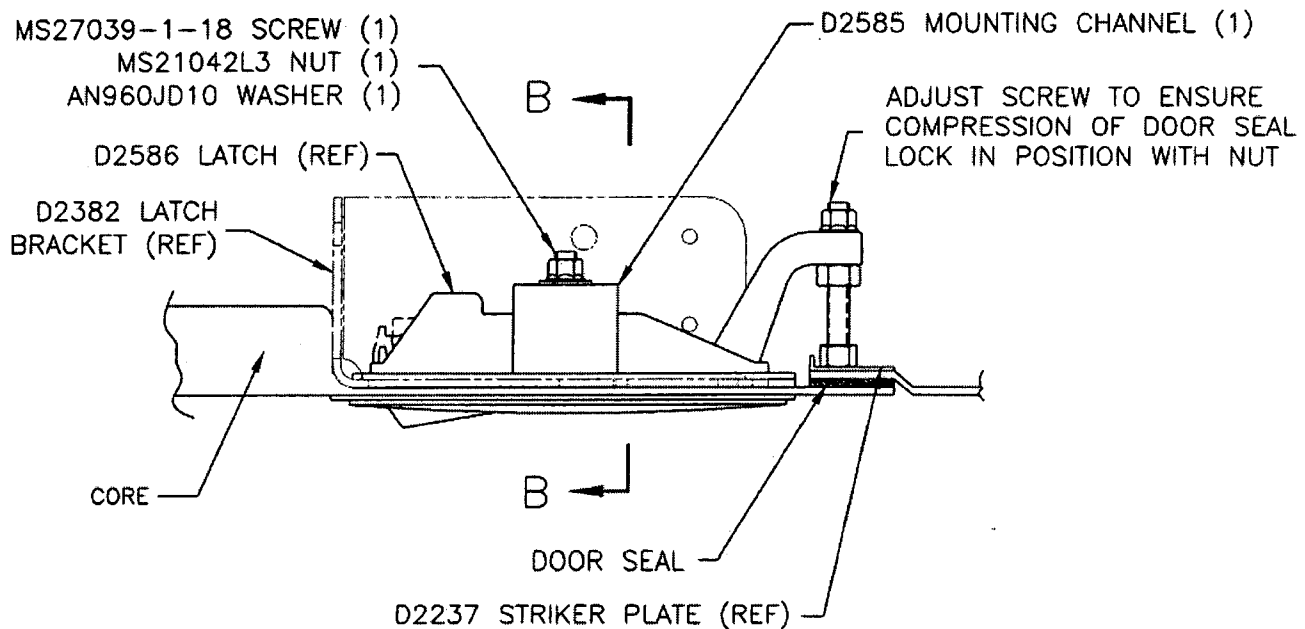
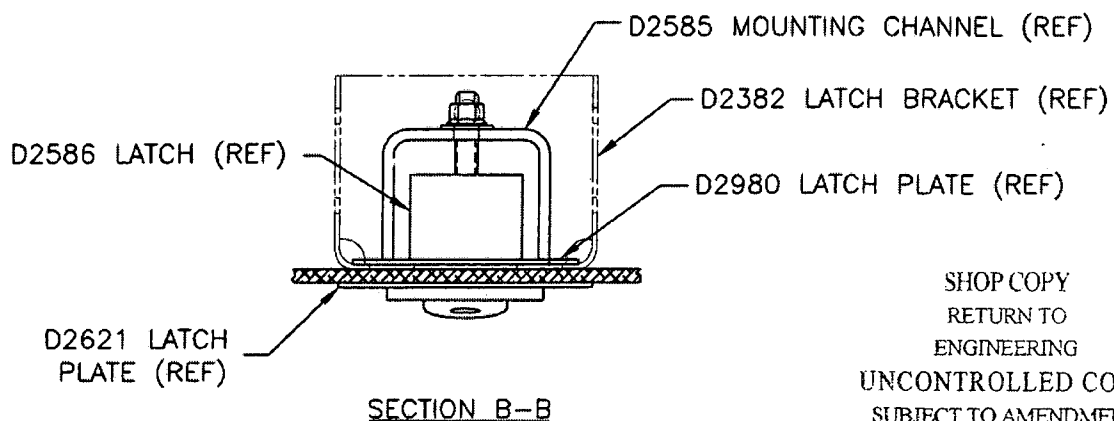


FIGURE 2: TYPICAL LATCH INSTALLATION



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 User: Kim Johnston

## Process Sheet

10

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH MODIFICATION KIT (AFT & SIDE DOOR)
Job Number	: 25905		
Estimate Number	: 12006		
P.O. Number	:	Part Number	: DSI 9189011
This Issue	: 2/23/2006 S.O. No. :	Drawing Number	: DSI 9189 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 3/10/2006 Qty: 4 Um: Each
Checked & Approved By	: <u>06.02.23</u>		
Comment	: Est. A 00.06.26 New Issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL  
 Provide photocopy of DSI 9189

2.0	D2463	1/2" Seal
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Comment: Qty.: 0.2083 f(s)/Unit Total : 0.8332 f(s)  
 Neoprene Seal

Pick:

Qty	Part number	Description	Batch
2	D2463-0025	Neoprene seal	

3.0	D2585	Latch Clamp
-----	-------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Latch Clamp

Pick:

Qty	Part number	Description	Batch
2	D2585	Mouting channel	

REFERENCE ONLY

4.0	D2586	Door Latch
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Door Latch

Pick:

Qty	Part number	Description	Batch
2	D2586	Latch	